

Work Order ID 108033-2

Split

Ship today 18/10

108033

Page 1

October-07-13 9:07:00 AM

Item ID: D4095-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Assembly

Start Date: 10/07/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/07/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 13-10-08

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4095	B								
100		0.00							
100	FLOW WATER JET								
Waterjet		0.00							
FLOW CNC Waterjet									
	Memo								
	1-Cut as per Dwg (D4095-1)								
	Dwg Rev: <u>0</u>								
	Prog Rev: <u>0</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC		0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00	DAS 27 9-89						
120									
QC		0.00							
Quality Control									

13-10-15

4

4

13-10-14

Work Order ID 108033***108033***

Page 4

October-07-13 9:07:00 AM

Item ID: D4095-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearplate Assembly

Stop

NS2

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>Shp</i>				1		
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>STFP</u> Memo	0.00 0.00					1		DAS 33 9-89 13-10-18
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>ff/11/13-18</i>

pd/13-10-11

Picklist Print

October-07-13 9:07:00 AM

Page 1

Work Order ID: 108033

Parent Item: D4095-041

Start Date: 10/07/13

Required Date: 10/07/13

Parent Item Name: Wearplate Assembly

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	513.3940	2.275	9.5789472		EL 13-10-14	

Location	Loc Qty	Loc Code
MAT020	513.3939998	
I23136	140.2	
M126159	31.5	
<u>M126915</u>	341.694	<u>7.6</u>

DART AEROSPACE LTD	Work Order:	108033
Description: Wearplate	Part Number:	D4095-1
Inspection Dwg: D4095 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
00.19	+0.005/-0.001	0.19	✓		JKM01	
0.300	+/-0.010	0.303	—		"	
0.300	+/-0.010	0.302	✓		"	
2.432	+/-0.010	2.44	—		"	
3.227	+/-0.010	3.221	✓		"	
4.06	+/-0.030	4.05	✓		"	
4.98	+/-0.030	4.984	✓		"	
8.43	+/-0.030	8.422	—		"	
9.22	+/-0.030	9.22	✓		JKM06	
3.500	+/-0.010	3.5	✓		"	
24.750	+/-0.010	24.75	✓		"	
11.50	+/-0.030	11.5	✓		"	
11.472	+/-0.010	11.472	✓		"	
6.000	+/-0.010	6	✓		"	
12.104	+/-0.010	12.104	✓		"	
18.000	+/-0.010	18.	✓		"	
30.000	+/-0.010	30.	✓		"	
9.00	+/-0.030	9	✓		"	
36.000	+/-0.010	36	—		"	
38.87	+/-0.030	38.875	✓		"	
2.50	+/-0.030	2.5	✓		"	
0.063	+/-0.010	0.06	✓		JKM01	
			DAS			

27

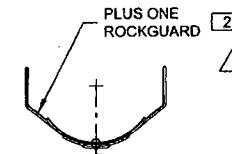
Measured by:	EL	Audited by:	9-89	Preliminary Approval:	
Date:	13-10-14	Date:	13-10-15	Date:	

Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-041	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	

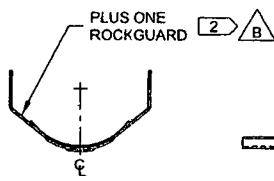
ITEM	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
	-041	-043	-045	-047	-049	-051	
1	X					D4095-041	WEARPLATE ASSEMBLY
2		X				D4095-043	WEARPLATE ASSEMBLY
3			X			D4095-045	WEARPLATE ASSEMBLY
4				X		D4095-047	WEARPAD ASSEMBLY
5					X	D4095-049	WEARPAD ASSEMBLY
6						X D4095-051	WEARPAD ASSEMBLY
7	1					D4095-1	WEARPLATE
8		1				D4095-3	WEARPLATE
9			1			D4095-5	WEARPLATE
10				1		D4095-7	WEARPAD
11					1	D4095-9	WEARPAD
12						1 D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)

108033 MLS B

13-10-08



D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY

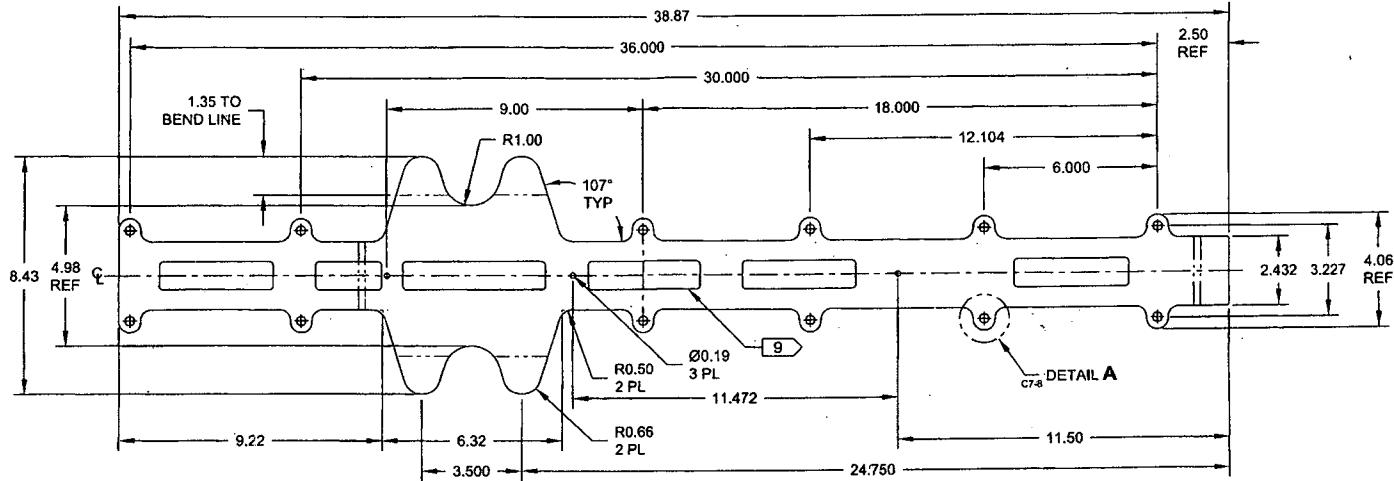
RELEASED
2011-10-31

D4095-041/-043/-045/-047/-049/-051 NOTES:

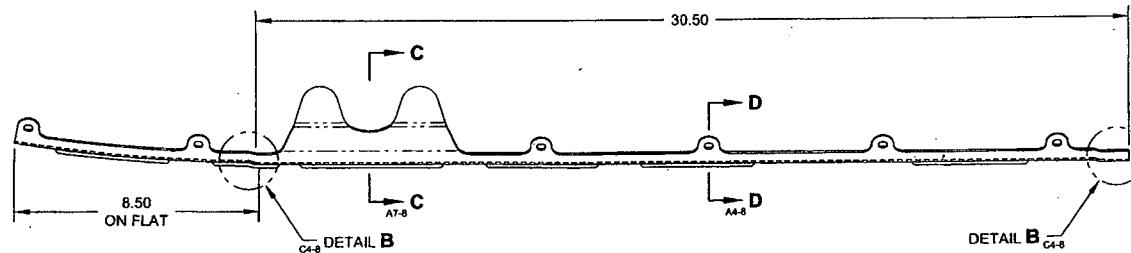
- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK B
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1-1F/33F: 4715 PLUS ONE ROCKGUARD REPLACES D4095-1/3; ADDED D4095-5/-7-9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	100	DRAWING NO.	REV. B
MFG. APPR.	100	D4095	SHEET 1 OF 8
APPROVED	100	TITLE	SCALE
DE APPR.	100	WEARPLATE	NTS
DATE	11.10.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, COPIED OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE, LTD.	

108033



D4095-1F FLAT PATTERN



D4095-1 BENDING DETAIL

(MAKE FROM D4095-1F)

D4095-1/-1F/-3/-3F/-5/-5F/-7/-7F/-9/-9F/11/-11F NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; D4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

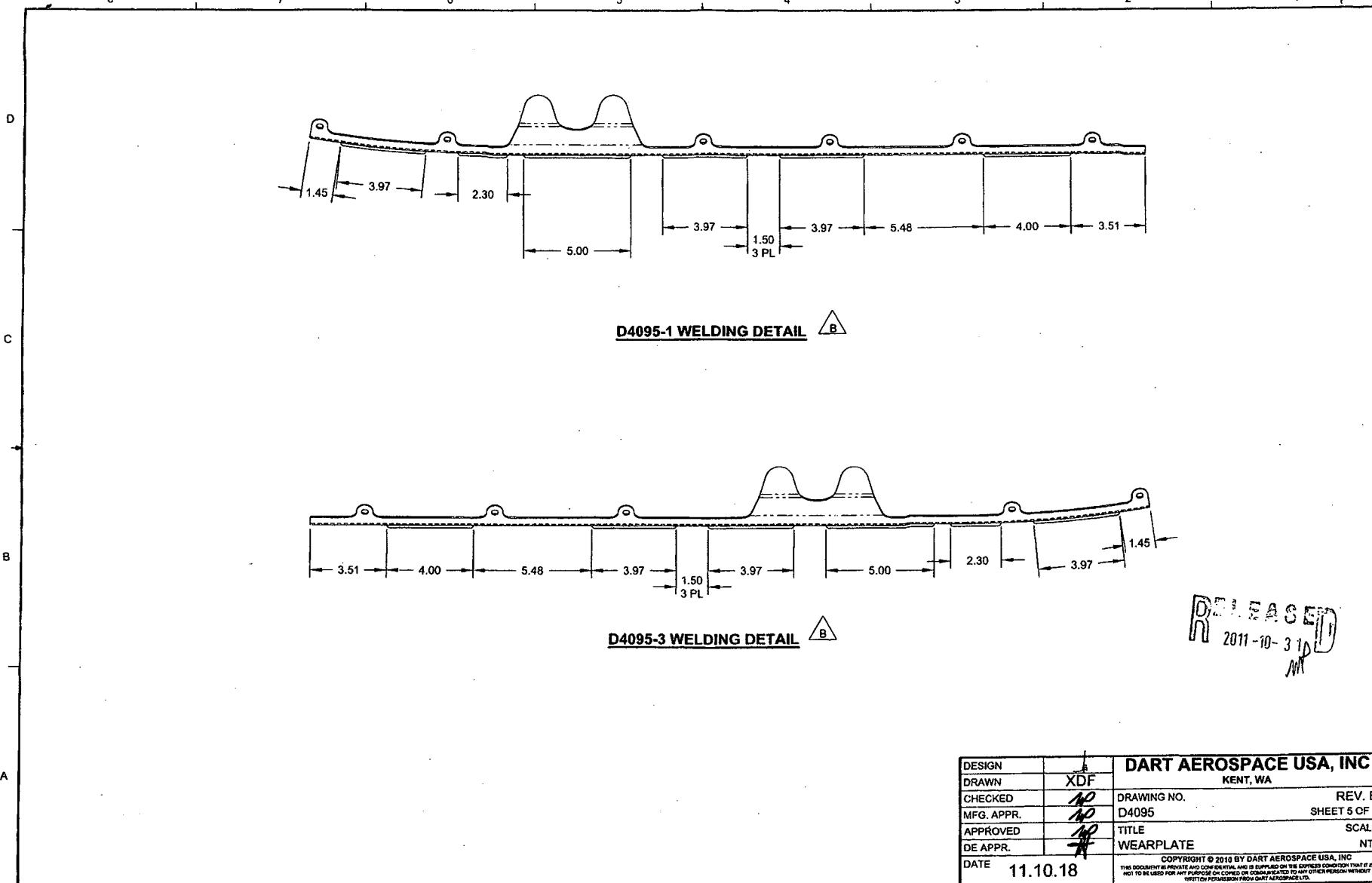
DART AEROSPACE USA, INC	
	KENT, WA
DRAWN	XDF
CHECKED	10
MFG. APPR.	10
APPROVED	10
DE APPR.	10
DATE	11.10.18

REV. B
DRAWING NO. D4095
SHEET 3 OF 8
TITLE WEARPLATE
SCALE NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

108033



8

7

6

5

4

3

2

1

D

D

C

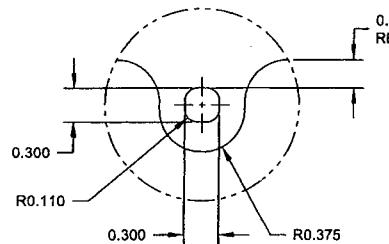
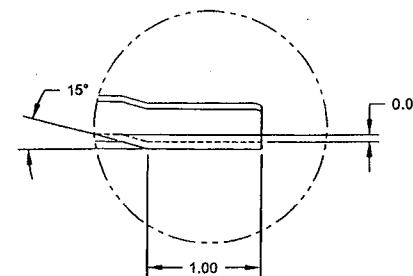
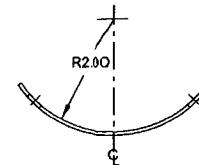
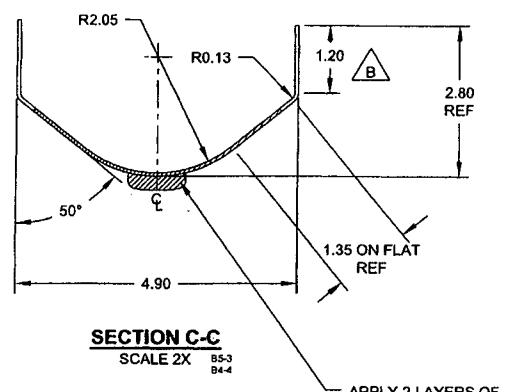
C

B

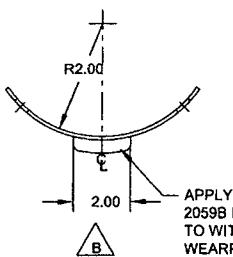
B

A

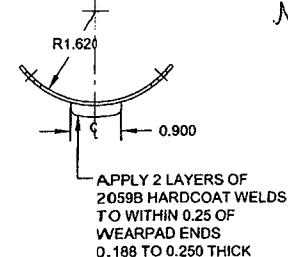
A

**DETAIL A: TAB DETAIL**SCALE 4X
C3-3
C8-4
D3-6
D2-7**DETAIL B: JOGGLE DETAIL**SCALE 4X
B2-3
B2-3
B3-4
B2-6**SECTION E-E**SCALE 2X
B5-6
B2-7**SECTION C-C**SCALE 2X
B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

**SECTION D-D**SCALE 2X
B5-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

**SECTION F-F**SCALE 2X
B5-7
B7-7**DART AEROSPACE USA, INC**

KENT, WA

DESIGN		DRAWING NO. D4095 TITLE WEARPLATE	REV. B SHEET 8 OF 8 SCALE NTS
DRAWN	XDF		
CHECKED	10/10		
MFG. APPR.	10/10		
APPROVED	10/10		
DE APPR.	10/10		

DATE 11.10.18

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